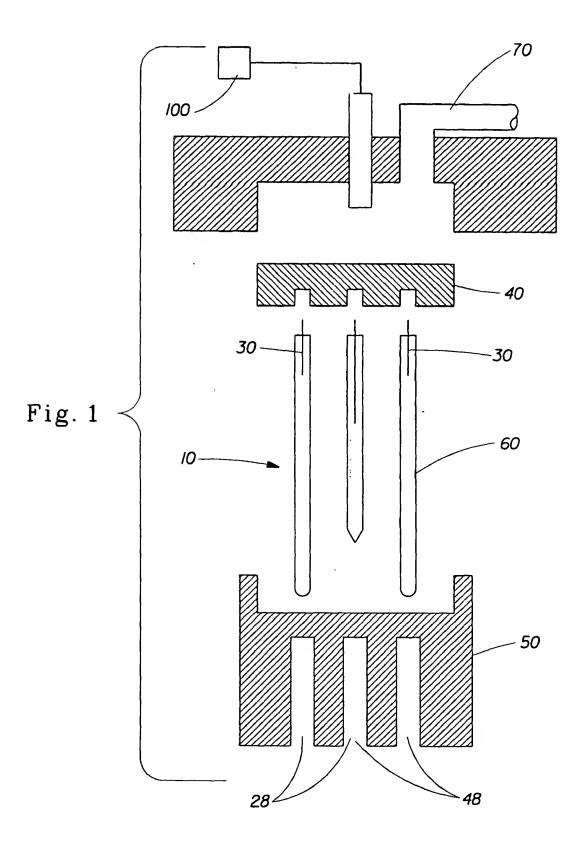


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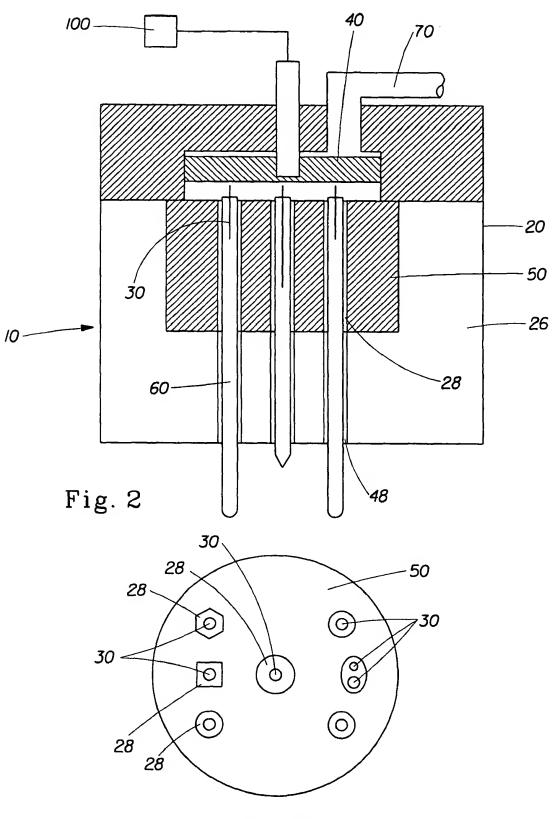


Fig. 3





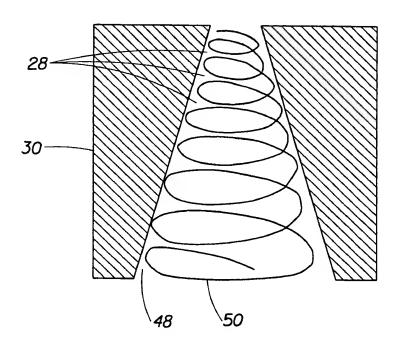
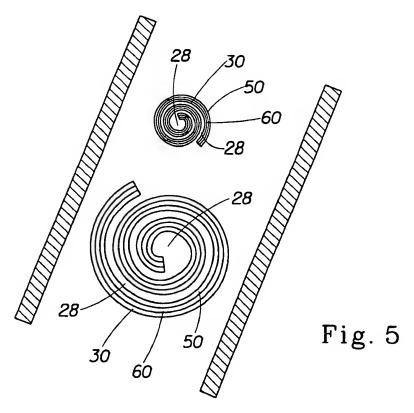


Fig. 4



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Workpiece Energy

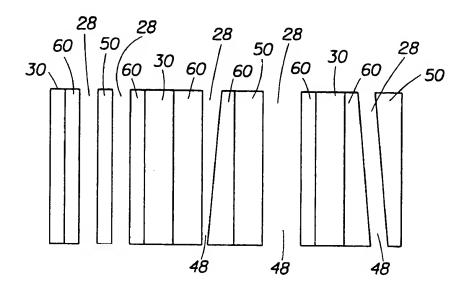


Fig. 6

